

# Work Order ID 70136

Friday, May 27, 2011 11:40:46 AM



Page 1

Item ID:	D3838-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	5/27/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	6/3/2011	Req'd Qty:	2.00		Customer:	

## Reference:

Approvals:	Process Plan:		Date:	11-05-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100  
 Large Fab  
 Large Fab  
 Large Fab

0.00  
 Memo  
 0.00  
 1- cut D3838-1 and D3838-3 rib as per dwg D3838  
 2- remove identification markings  
 3- deburr  
 4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838  
 A/R ER316 S.S. Rod Batch: 117884  
 5- c'sink hole as per dwg  
 6- grind weld flush where indicated on dwg D3838  
 7- weld D3759-1 bushing as per dwg D3838  
 A/R ER316 S.S. Rod Batch: 117884  
 8- grind bushing weld flush as per dwg dwg D3838  
 9- deburr hole if necessary

②  
 P(11-06-07.05)

SAD 11-06-28

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70136**

Friday, May 27, 2011 11:40:47 AM



Page 2

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 5/27/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

BE 11/07/06  
11.07.06

2

p



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

8 units

42



QC

Memo

0.00

Quality Control

241

150

Identify as per dwg &amp; Stock Location: B/C

0.00



Packaging

Memo

0.00

Packaging

PC 11.07.06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






**NOTE:** Date & initial all entries



**Work Order ID 70136**


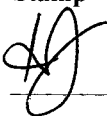
Friday, May 27, 2011 11:40:47 AM



Page 3

Item ID: D3838-041 Accept  Setup Start   
Revision ID:  
Item Name: Rib Assembly (Basket Lid, LH) Stop   
Start Date: 5/27/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 6/3/2011 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						11/7/6 	

MC  
11-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Friday, May 27, 2011 11:40:54 AM

Page 1

Work Order ID: 70136

Parent Item: D3838-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 5/27/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No				Each	311.0000		2			
													
Bushing													

Location Loc Qty Loc Code

WA	200	
69202	200	
WA005	111	
66489	2	
66870	109	

M304TS0.750W.065		Purchased	No				f	1,286.816	1.0317	2.172			
													
304 SQ Tube .75x.75x.065W													

Location Loc Qty Loc Code

MAT018	1140.8565	
117598	1000	
117636	140.8565	
WA007	145.9601906	
116267	141.654472	
116763	4.3057186	

2 PPL 11.07.05

2.172  
SAD 11-06-28

2.172

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

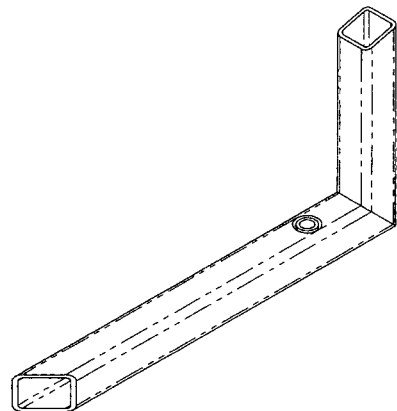
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

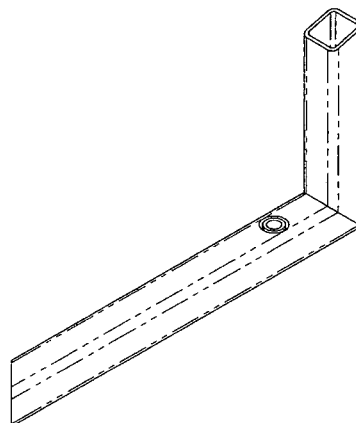
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70134  
PR11-05-27

RELEASED  
08/11/08

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3838		REV. A	SHEET 1 OF 3
TITLE RIB ASSY (BASKET LID)		SCALE	NTS
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**Dart Aerospace Ltd**

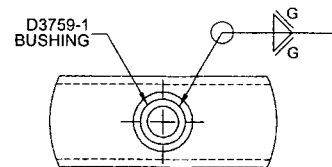
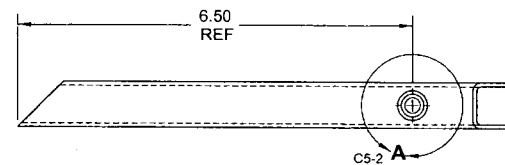
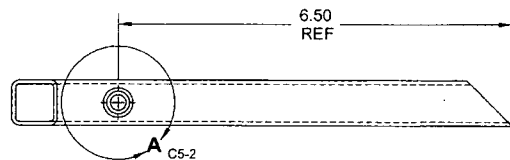
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

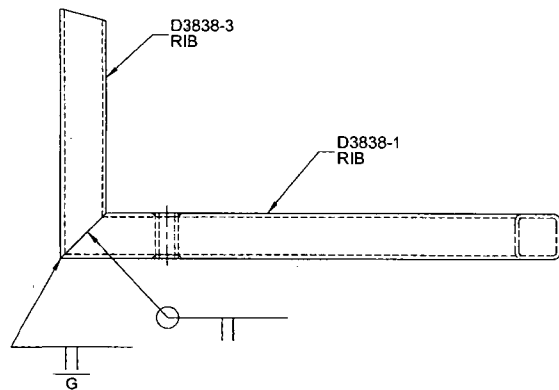
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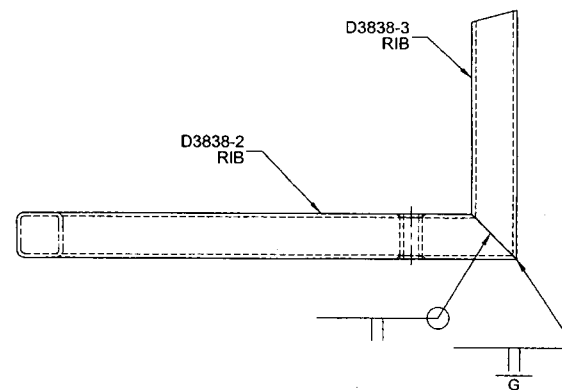
**NOTE:** Date & initial all entries



**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, LH)**

*ULO 10136*

**RELEASED**  
*08/10/08*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SS</i>	DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.	<i>SS</i>		SHEET 2 OF 3
APPROVED	<i>SS</i>	TITLE <b>RIB ASSY (BASKET LID)</b>	SCALE NTS
DE APPR.	<i>SS</i>		
DATE	<b>08.10.08</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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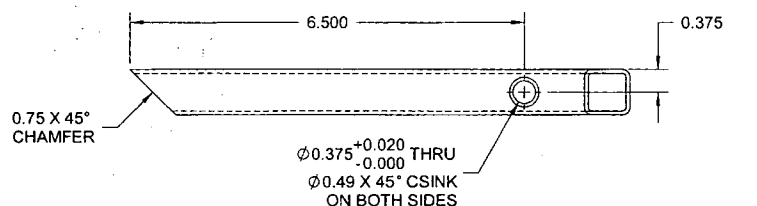
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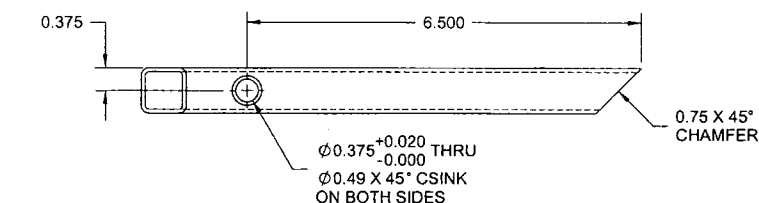
NOTE: Date & initial all entries

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D

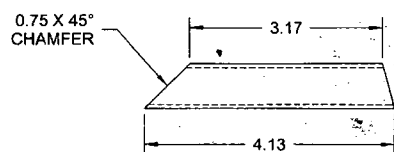


**D3838-1 RIB**

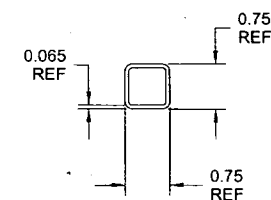


**D3838-2 RIB**

C



**D3838-3 RIB**



**TYPICAL SECTION  
VIEW**

*u/o 70134*

**RELEASED**  
*25/11/18*

A

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.	<i>[Signature]</i>		SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB ASSY (BASKET LID)</b>	NTS
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A

B

C

D

8 7 6 5 4 3 2 1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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